

Date: Monday, 09/02/2009 4:30:46 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER
Job Number :	45651		
Estimate Number :	13530		
P.O. Number :		Part Number :	PB674300127
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.4
First Issue :	/ /	Project Number :	N/A
Previous Run :	45650	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/04/2009
Written By :		Qty:	3
		Um:	Each
Checked & Approved By :	mf 09-03-03		
Comment :	Est Rev:A 08-07-29 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300135	PB67-43001-35 Lower Pad Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PB67-43001-35 Lower Pad Assembly

batch: 40068 x 2, 41378 x 1

mf 09-03-03

2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PB67-43001-31 Upper Restraint Weldment

batch: 41377

mf 09-03-03

3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PB67-43001-29 Blade Positioner Weldment

batch: 1 x 43056, B 45032 x 2

mf 09-03-03

4.0	PB6743001285	PB67-43001-285 Upper Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PB67-43001-285 Upper Tube

batch: 44974

mf 09-03-03

5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PB67-43001-19 Inner Tube and Retainer Bu

batch: 45039

mf 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45651

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Extension Tube Adjustmnt

batch: 44971

CMF 09-03-03

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Handle Adjustmnt Fitting

batch: B41296 Swap P.T.O.

1 x 46246
B41375 x 2

CMF 09-03-03

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clamp Bushing

40060

CMF 09-03-03

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

BOLT

batch: m110155

CMF 09-03-03

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Washer

batch: 110139

CMF 09-03-03

11.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

WASHER

batch: m18057

CMF 09-03-03

12.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

WASHER

batch: m108986

CMF 09-03-03

Dart Aerospace Ltd

W/O: 45651		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-03-03	7.	Part PB6743001-289-B# 41296 is sup. Replace with PB6743001 x 2 B# 41345 -289 J10 1 B 46246 -289 J10	MF	09-03-12	2.	09.03.12	09.03.12

Part No: PB67-43001-27 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45651

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

batch: m108183

MF 09-03-03

14.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total: 21.0000 Each(s)

Screw

batch: m107378

MF 09-03-03

15.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total: 21.0000 Each(s)

WASHER

batch: m109031

MF 09-03-03

16.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Inventory

batch: m18431

MF 09-03-03

17.0

MS24694S102

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Screw

batch: m14604

MF 09-03-03

18.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

BOLT

batch: m18057

MF 09-03-03

19.0

NAS1149F0532P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

WASHER

m18057

MF 09-03-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-03-07	17.0 18.0 19.0 20.0 21.0	REMOVE STEPS - NOT APPLICABLE.	Pl	09-03-04		09-03-07	2/3/5	
09-03-04	14.00	Screw too long wants to come thru the pad. Replace MS27039-109 By MS27039-109 M106815 - 1-06 ONE	Pl	09-03-04	5	09-03-04	2/3/5	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:46 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45651

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

batch: m110382.

MF 09-03-03

21.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

WASHER

batch: m108986

MF 09-03-03

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube

2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg

3- assemble all parts as per dwg PB67-43001

m-109/03/04

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/05 (x3)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Blade ~~with~~ Kit section

MF 09-03-12

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12

Job Completion



MF 09-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.05	220	IT-4-2001-35 CONTACT CEMENT OVERSPILL ON EXPOSED SURFACE OF P67-43001-35. P.C. IMPROPER USE OF CONTACT CEMENT.	09.03.05 OSI OAZ	TRY CLEANING OFF CONTACT CEMENT. SCRAP PART IF UNSUCCESSFUL.			09.03.05 OSI OAZ	

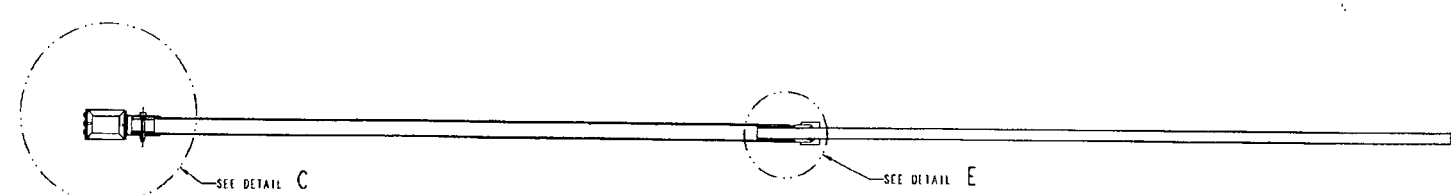
NOTE: Date & initial all entries

RELEASED
4-26-21-2

8 7 6 5 4 3 2 1

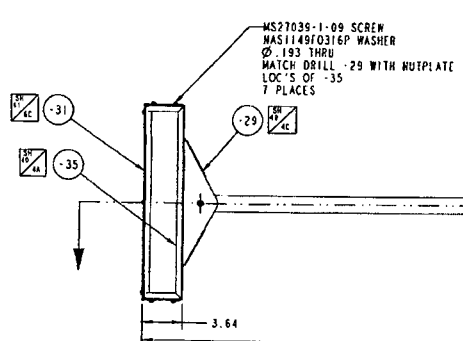
D

D



C

C

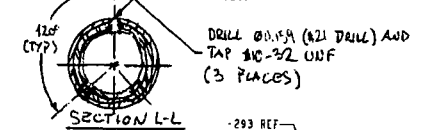


B

B

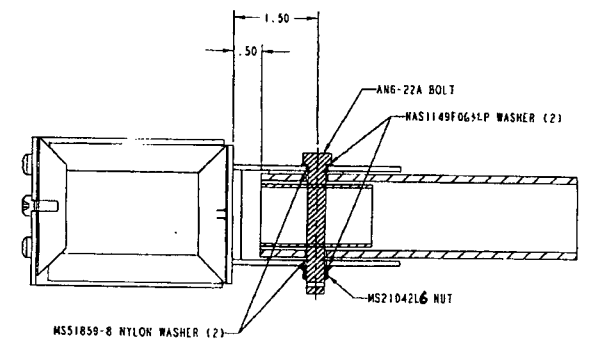
① -27 BLADE POSITIONER

FULLY EXTENDED THIS VIEW
SCALE 0.200



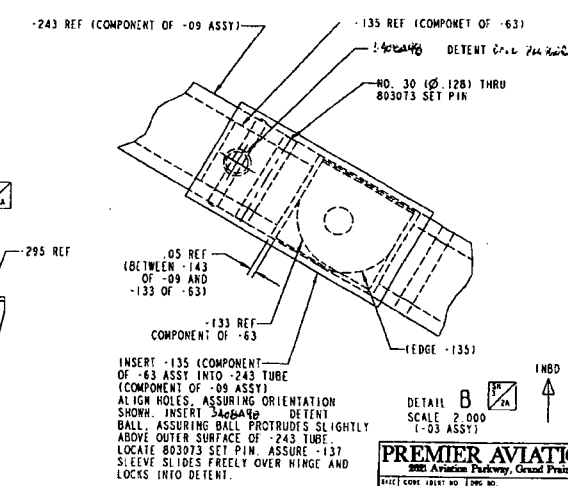
A

A



DETAIL C
SCALE 1.000
(-27 ASSY)

DETAIL E
SCALE 1.000
(-27 ASSY)



DETAIL B
SCALE 2.000
(-03 ASSY)

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75052
D10SU8 B67-43001

ORIGINAL

#45651